

Work Order ID 149694

Tuesday, July 26, 2016 10:26:46 AM

149694

Page 1

Item ID: D4950-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tailboom Mount
 Start Date: 8/17/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/19/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: JUL 27 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4950	B								

100		0.00							
100	Small Fab					<u>2</u>	<u>FF</u>	<u>AUG 12 2016</u>	
Small Fab	Memo	0.08							
Small Fab	1- Assemble with a thin layer of Proseal between the mating surfaces as per dwg D4950 A/R Proseal 890 batch: <u>M134500</u>								
110	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
110						<u>(2)</u>		<u>AUG 17 2016</u>	
QC	Memo	0.01							
Quality Control									
113		0.00							DAS 41 9-89
113						<u>2</u>		<u>16-8-16</u>	
SprayPaint	Memo	0.10							
Spray Painting	Prime as per dwg and QSI A/R Primer Batch: <u>135172</u>								

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Item ID: D4950-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Tailboom Mount

Start Date: 8/17/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/19/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115

QC14- Inspect Spray Paint

0.00

115

QC

Memo

0.01

Quality Control

DAS
38
9-89
AUG 17 2016

120

Identify as per dwg & Stock Location

0.00

120

Packaging

Memo

0.00

Packaging

DAS
6
9-89

AUG 18 2016

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.03

Quality Control

DAS
21
9-89

AUG 18 2016

DAS
21
9-89

AUG 18 2016

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 149694

149694

Parent Item: D4950-043

D4950-043

Parent Item Name: Tailboom Mount

Start Date: 8/17/2016

Required Date: 8/19/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.09.24 NEW ISSUE DD VERF:JLM
REV:B 14.01.16 AS PER DWG REV.B DD VERF:JLM

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4950-3		Manufactured	No				Each	9.0000		2			
D4950-3									**		FF	AUG 12 2016	
Mount													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST139				9					
					144566			9		<u>2</u>			
D3868-3		Manufactured	No				Each	38.0000		2			
D3868-3									**		FF	AUG 12 2016	
Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST056				38					
					106578			38		<u>2</u>			
D3868-5		Manufactured	No				Each	6.0000		2			
D3868-5									**		FF	AUG 12 2016	
Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST056				6					
					111656			6		<u>2</u>			
DAS 30 9-89													
MS20426AD3-5		Purchased	No				Each	3,166.000		8			
MS20426AD3-5									**		FF	AUG 12 2016	
Rivet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA	4533			2182		<u>8</u>			
					M120123			78					
					M133988			2104					
				ST312				984					
					M133988			984					

NOT pulled

DQA: _____ Date: _____

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